



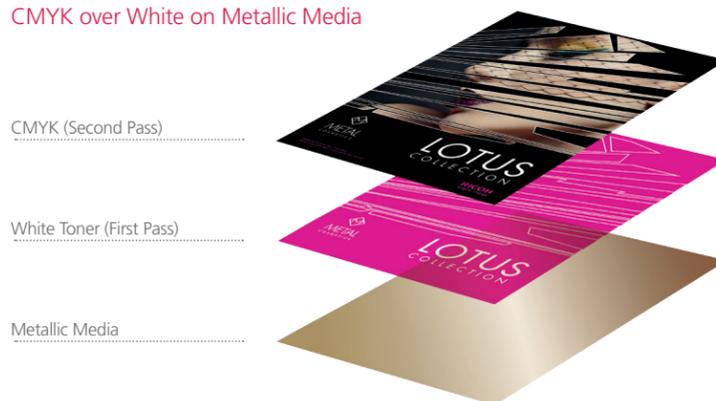
Creating the 5th Color – White, to create a Metallic Effect

This tutorial will explain and demonstrate how to print a **White** Spot Color on **Metallic Media**, creating a mask for the metallic media to show through.

In this example, a swatch and layer will be created in Illustrator which, when outputted, will simulate metallic properties in specific areas on the final output.

This is a **2-Pass Process**, where the 5th Color layer is printed first, followed by CMYK. The areas that do not have a 5th Color base layer will yield a metallic effect. 2 PDF files will be created and printed, resulting in one final print.

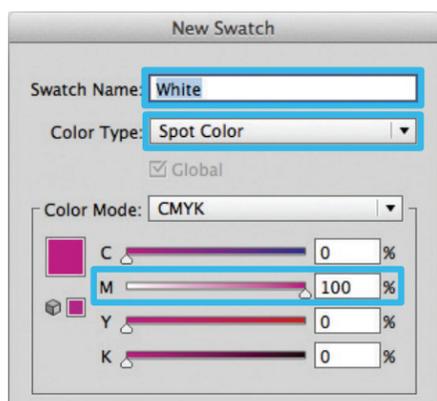
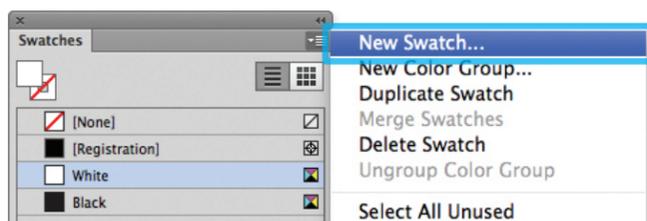
CMYK over White on Metallic Media



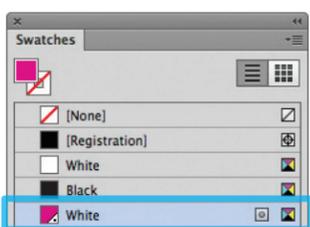
1. Open or create the InDesign / Illustrator file you are looking to enhance with White Toner.

2. Create a **New Swatch**.

- Name the swatch "**White**."
- Select "**Spot Color**" for Color Type.
- It's recommended to choose a color that stands out, such as 100% Magenta, to easily see where the White will print.

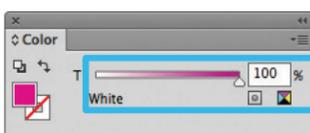
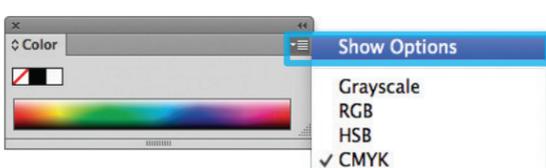


3. The White / Magenta Spot Color will represent the White Toner.

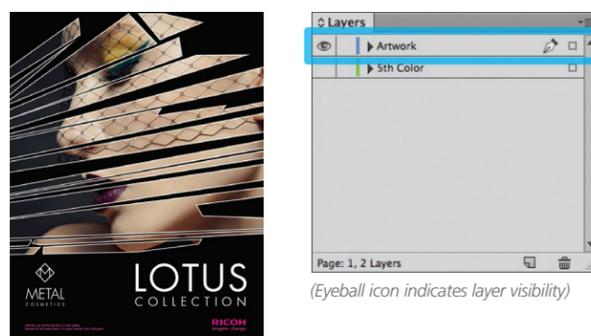


4. The amount of toner density can be adjusted in the color panel on the Density Scale.

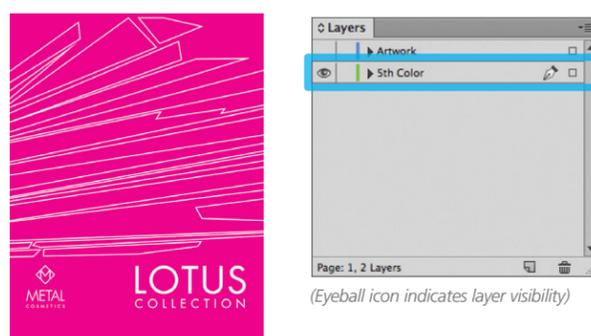
- From the Menu bar select "Window" then "Color" to display the Color Panel. If the Density Scale is not displayed, select *Show Options*.
- Drag the Density Scale or enter the percentage in the box to adjust the density.



5. Create an Artwork layer and a 5th Color layer in the layout. The 5th Color layer will become the 1st Pass White Toner Base Layer. The Artwork layer will become the 2nd Pass CMYK Layer.



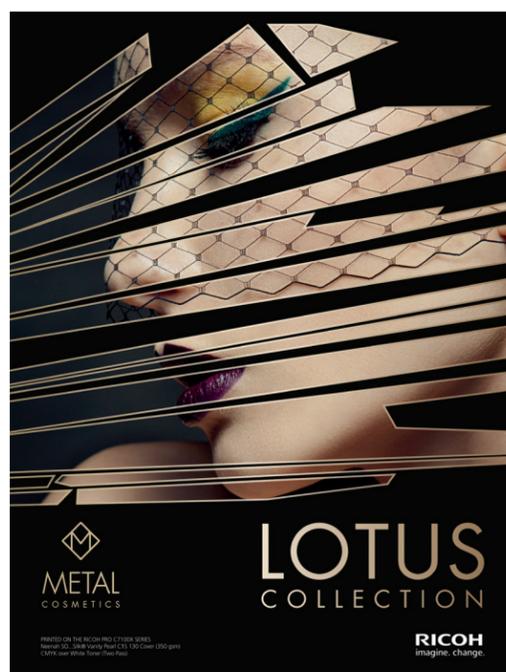
(Eyeball icon indicates layer visibility)



(Eyeball icon indicates layer visibility)

6. The Magenta / White layer in this example covers the majority of the layout allowing only small portions of the metallic media to show through.

Any White areas in the "Artwork" layer will not print, creating a metallic effect.



Broken glass outlines reveal metallic media.

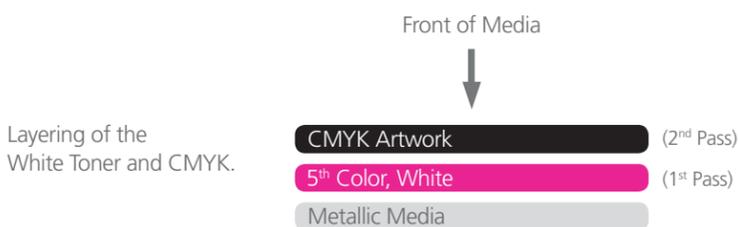
Metal Cosmetics logo and Lotus Collection reveal metallic media.

Ricoh logo and media callout will print White (using the 5th Color) on the 2nd Pass, which will be a double hit of White Toner.

Womans face and black background print on top of the White Toner Base Layer, (which is concealing the metallic media.)

Continued on back page

7. After the design / layout is finalized, isolate elements and export 2 PDFs.



NOTE: To ensure acceptable registration and toner coverage, (with relation to the 1st Pass White Layer), the layout *may* need to be **Trapped** by either Choking or Spreading the respective layers. They both solve the same issue.

1. **Choke:** in which the *White Layer* coverage is contracted, increasing the percentage of substrate that will show through.
2. **Spread:** in which the *Artwork Layer* coverage is expanded, reducing the percentage of substrate that will show through.

Both techniques require the **Offset Path** tool, assuming Illustrator is being used, in the creation of these examples. (Object > Path > **Offset Path**).



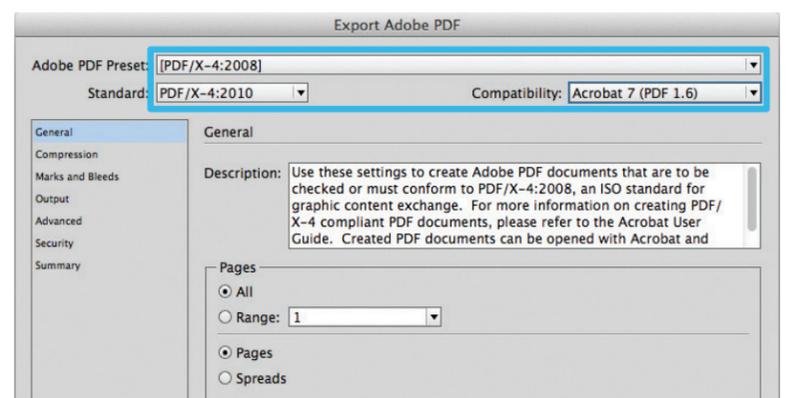
8. Save the **First PDF** to contain only the **5th Color, White Layer**.
(Only the isolated 5th Color layer should be visible.)

Save the **Second PDF** to contain only the **CMYK Artwork Layer**.
(Only the CMYK artwork should be visible.)

To save the 2 individual files with only their specific layers, simply **Turn Off** the layer that isn't required by clicking the **"Eyeball"** icon on the Layers panel (shown in **Step 5**).

9. Export **2 PDF files** as PDF/X-4 (PDF1.6 or newer).

The **First file** should be the **5th Color, White Layer** only.
The **Second file** should be the **CMYK Artwork Layer** only.



10. Print the **5th Color, White Layer** PDF first. Once the 1st Pass is completed, then print the **CMYK Artwork Layer** PDF.

Refer to "Printing the 5th Color from Fiercy® Command WorkStation" for steps on Printing PDFs.